

Work Order ID 54958

January 5, 2010 10:45:15 AM



Page 1

Item ID: D350-636-105A

Accept



Setup Start



Revision ID:

Stop



Item Name: Wedge Installation

Start Date: 05/01/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 5.00

Customer:

Reference:

Run Start

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54958

January 5, 2010 10:45:16 AM



Page 2

Item ID: D350-636-105A

Accept



Setup Start



Revision ID:

Stop



Item Name: Wedge Installation

Start Date: 05/01/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D3550-636-105A/ DSI9456

Location:

PPP rev: A

10/01/11 (5)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/11 HJ
10-1-08
(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:45:20 AM

Page 1

Work Order ID: 54958

Parent Item: D350-636-105A

Parent Item Name: Wedge Installation

Comments:

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3926-1	1 x 2	Manufactured	No			110	Each	12.0000	10.0000	2x		
												
Wedge												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

12

53947

12

MS21042L3

x4

Purchased

No

110

Each

3.014.000 20.0000



Nut

B

10-1-7

(5x) 50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3014

110844

35

111274

27

111668

64

112314

1388

112385

500

113523

300

113537

700

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:45:20 AM

Work Order ID: 54958

Parent Item: D350-636-105A

Parent Item Name: Wedge Installation


Comments:

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS24693-S276  SCREW	84	Purchased	No			110	Each	110.0000	20.0000		10-1-7	sl

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 110

104374

110

110 Each 1,394.0000 20.0000

20

10-1-7

sl (50)

NAS1149D0363J

Purchased

No

Washer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 1394

113064

194

113288

1000

113368

200

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 54958
Rev 10-1-05

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV. F OR EARLIER

REF. FAA STC: SR00646SE

REF. TCCA STC: SH99-7

REF. CAA AIRWORTHINESS APPROVAL NOTE: 28081, 28082

The D350-636-105A/B Wedge Kits can be installed on D350-636-011/-012/-013/-014 Skidtube installations to help prevent the D2741 blade from getting snagged on objects on the ground during take-off. The D350-636-105A Wedge Kit is compatible with Apical Float Systems per STC SR00470LA, SR00645LA and SR00831LA with the low angle float extensions but is not compatible with OEM skidtubes. The D350-636-105B Wedge Kit is compatible with non-float tube equipped skidtubes but is not compatible with OEM skidtubes.

The D350-636-105A/B Wedge kits are installed as follows:

- 1) Remove the D2741 blades from the D350-636 skidtube assemblies
- 2) Drill 2x $\varnothing 0.201$ (#7 drill) per D2741 blade as shown in Figure 1 Sheet 2 and deburr
- 3) Countersink the 2 holes $\varnothing 0.385 \times 100^\circ$ from the bottom of each D2741 blade
- 4) Position the D3926-1/-3 wedge on the top side of each D2741 blade centered between the left and right sides
- 5) Transfer drill 2x $\varnothing 0.201$ (#7 drill) from each D2741 blade to the D3926-1/-3 wedge and deburr
- 6) Touch up holes in D2741 blade with primer per Aircraft Maintenance Manual
- 7) Install the D3926-1 wedge on each D2741 blade using the hardware shown in Figure 2 Sheet 2
- 8) Install the D3926-3 wedge on each D2741 blade using the hardware shown in Figure 3 Sheet 3
- 9) Re-install the D2741 blade onto the D350-636 skidtube assembly in accordance with IIN-D350-636.
- 10) It is acceptable to install blade tape (abrasion strip material) on the float tube extension to prevent wear between the D3926-1 wedge and the float tube extension.

WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal	
		Arm	Moment	Arm	Moment
D350-636-105A Wedge Kit	0.50 lb 0.23 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.25 in 4.53 m	89.13 in-lb 1.04 m-kg
D350-636-105B Wedge Kit	0.50 lb 0.23 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.25 in 4.53 m	89.13 in-lb 1.04 m-kg

PARTS LIST

QTY. -105A	QTY. -105B	PART NUMBER	DESCRIPTION
X		D350-636-105A	Wedge Kit
	X	D350-636-105B	Wedge Kit
2		D3926-1	WEDGE
	2	D3926-3	WEDGE
4	4	M821042L3	NUT
4	4	M8246936276	SCREW
4	4	NAS1149D0363J	WASHER

A	NEW ISSUE	09.07.23
REV.	DESCRIPTION	BY DATE
DESIGN	AS	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	AS	
CHECKED	AS	DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9456 SHEET 1 OF 3
APPROVED	AS	TITLE SCALE
DE APPR.	AS	WEDGE KIT NTS
DATE	09.07.23	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

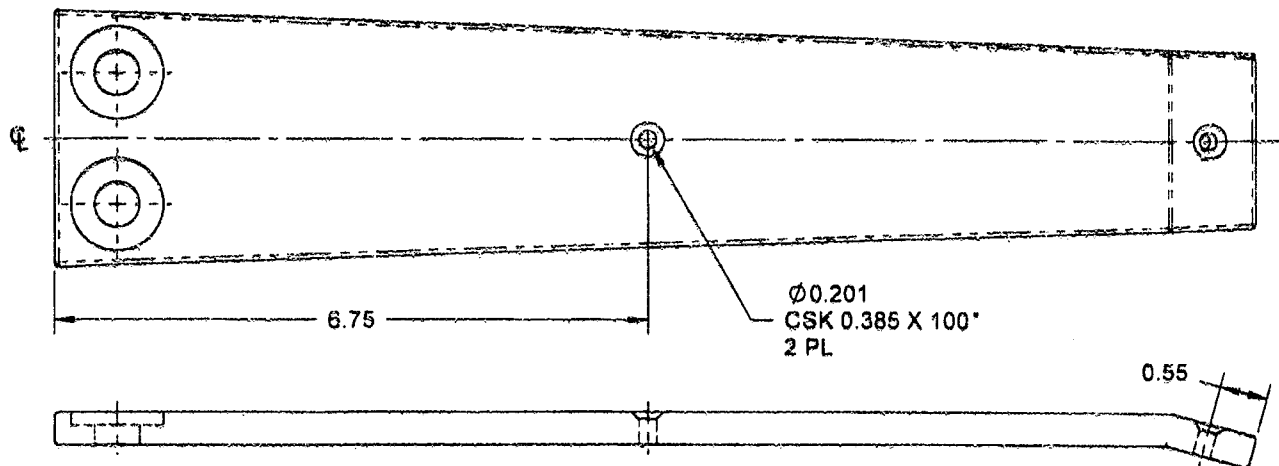


FIGURE 1: D2741 BLADE DRILLING DETAIL

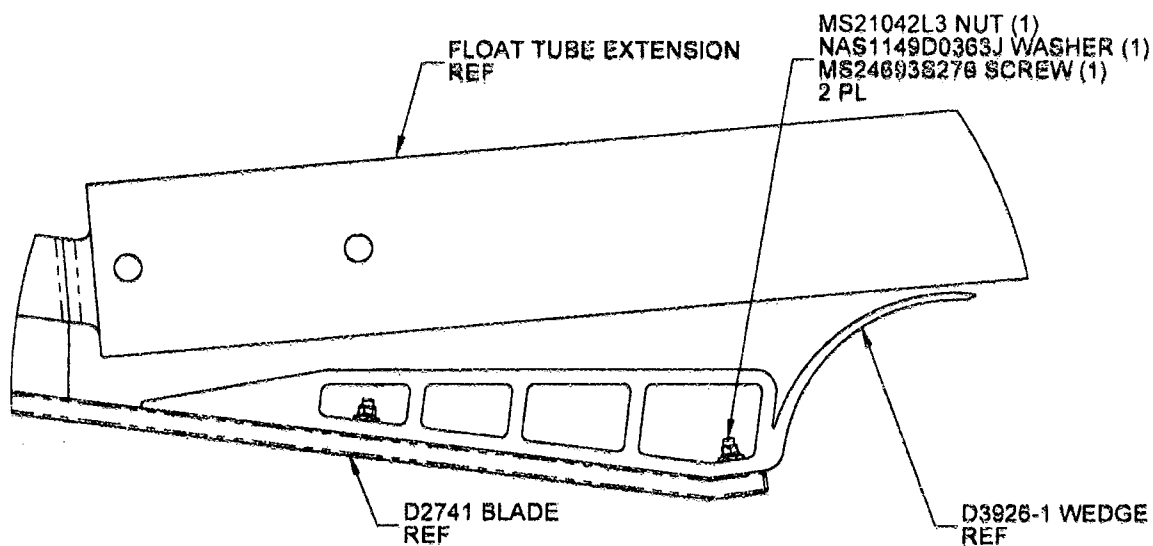


FIGURE 2: D3926-1 WEDGE INSTALLATION

W/O 54958

DESIGN	<i>AS</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
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CHECKED	<i>ASS</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9456	SHEET 2 OF 3
APPROVED	<i>NO</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	WEDGE KIT	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

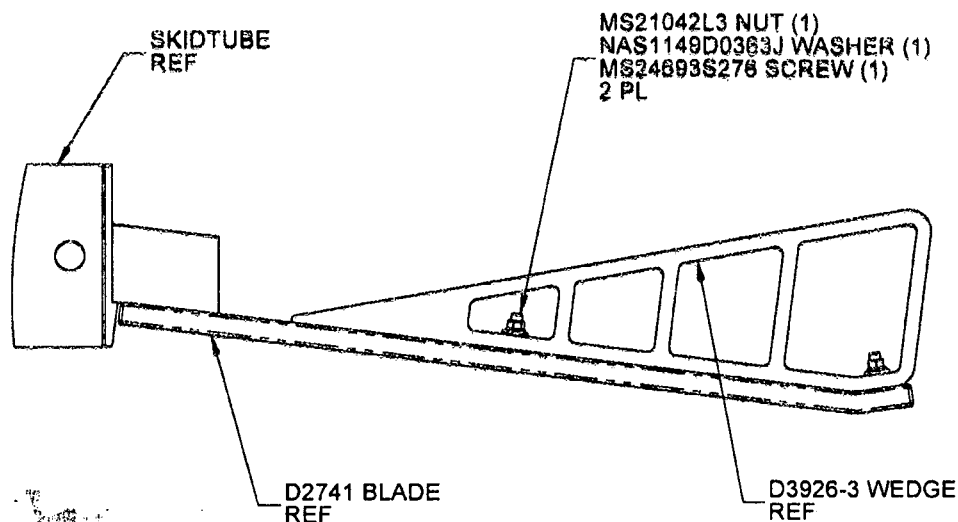


FIGURE 3: D3926-3 WEDGE INSTALLATION

w/b 54958

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CHECKED	<i>AS</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9456	SHEET 3 OF 3
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	WEDGE KIT	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV. F OR EARLIER

REF. FAA STC: SR00646SE

REF. TCCA STC: SH99-7

REF. CAA AIRWORTHINESS APPROVAL NOTE: 28081, 28082

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- 5) Transfer drill 2x $\varnothing 0.201$ (#7 drill) from each D2741 blade to the D3926-1/-3 wedge and deburr
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WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal	
		Arm	Moment	Arm	Moment
D350-636-105A Wedge Kit	0.50 lb 0.23 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.25 in 4.53 m	89.13 in-lb 1.04 m-kg
D350-636-105B Wedge Kit	0.50 lb 0.23 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.25 in 4.53 m	89.13 in-lb 1.04 m-kg

PARTS LIST

QTY. -105A,	QTY. -105B	PART NUMBER	DESCRIPTION
X		D350-636-105A	Wedge Kit
	X	D350-636-105B	Wedge Kit
2		D3926-1	WEDGE
	2	D3926-3	WEDGE
4	4	MS21042L3	NUT
4	4	MS24693S276	SCREW
4	4	NAS1149D0363J	WASHER

A	NEW ISSUE	09.07.23
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED	ASS	
MFG. APPR.	N/A	
APPROVED		
DE APPR.		
DATE	09.07.23	

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **DSI 9456** REV. A
SHEET 1 OF 3

TITLE **WEDGE KIT** SCALE NTS

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